

Process Sheet

Date: Tuesday, 4/4/2006 1:32:21 PM
User: Kim Johnston

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : LUG ASSEMBLY

Job Number : 26515

Estimate Number : 10913

P.O. Number : NIA

This Issue : 4/4/2006

S.O. No. : NIA

Prsht Rev. : NC

First Issue : NIA

Type : LARGE FAB ASSY

Previous Run : NIA

Part Number : D3405043

Drawing Number : D3405 REV A

Project Number : N/A

Drawing Revision : A

Material : NIA

Due Date : 4/27/2006

Qty: 10 Um: 30 Each

Written By : SEE COMMENT BELOW

Checked & Approved By : 06.04.04

Comment : Est A 05.09.01 New issue KJ/JLM

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING

Comment: PURCHASING

Issue P/O: 952

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3405

Material release note is required

Identify as D3405-3

06/04/06 (30)

2.0

D34053F

GHW Bracket

Comment: Qty.: 1.0000 U(s)/Unit Total: 30.0000 U(s)

G H W BRACKET

3.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

06/04/18 30

4.0

QC6

DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3405

06.04.24 30

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Deburr

Form using DT8204 as per Dwg D3405

MF 06.05.13
SB 06/05/15 10

Process Sheet

Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Part Number: D3405043



Machine Or Operation:

Description :

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

GHW Lug

Pick:

Qty Part number Description Batch

1 D3404-1 Lug

A/R SS Rod

A26775
M18712

AA 06/05/16 (10)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

AA 06/05/16 (10)

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-05-16 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-17 (10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/05/17 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5777

AP 06/05/17 (10)

02:42 PM

Process Sheet

Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Part Number: D3405043



Machine Or Operation:

Description :

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/18

18

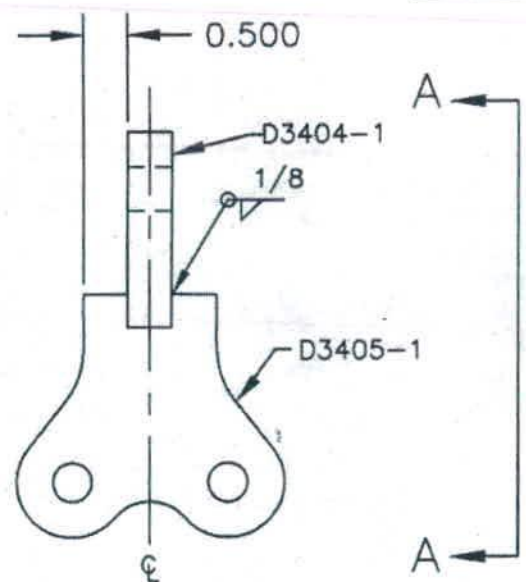
Completion



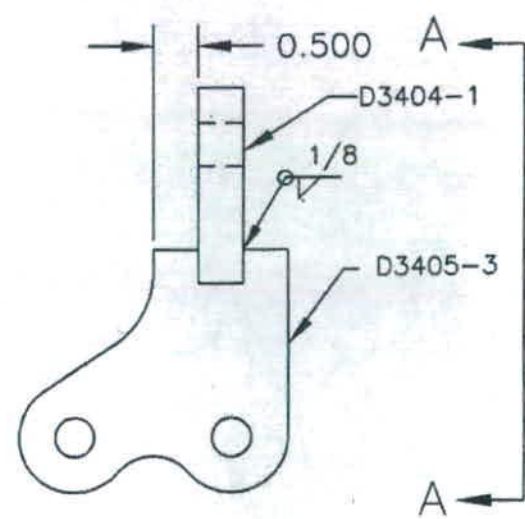
U 8005-18



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08		TITLE GHW LUG ASSEMBLY	SCALE 1:2
A	05.03.08	NEW ISSUE	



D3405-041 LUG ASSEMBLY

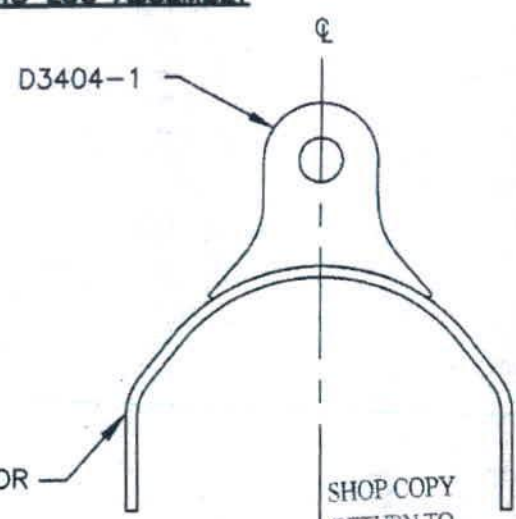


D3405-043 LUG ASSEMBLY

PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26515

D3405-041/-043 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

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003

INDUSTRIAL LASER CUTTING + DART

04/18/2006 10:05 FAX 604 946 4153

90277641

MATERIAL TEST/INSPECTION CERTIFICATE

YIEH MAU CORP.

INVOICE NO. : F06MC11
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

工廠: 高雄縣大寮市明德里445號
318, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL: (874) 272885 FAX: (874) 272885
CERTIFICATE NO. F06MC11
DATE OF ISSUE: 01/07/2004
PAGE: 4

SPECIFICATION : AISI 304
CUSTOMER : INTEGRIS METALS LTD.

ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50 mm					Chemical Composition (%)									
			KGS	LBS			YS	TS	EL	HRH	RV	C	Si	Mn	P	S	Ni	Cu	Fe		
							(MPa)	(MPa)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	(%)	
AISI 304, 2B FINISH, WITH PAPER INTERLEAVED, SCOTCH EDGE.																					
7427-4085	120A160"X 96"	1	1,444	3,183	YU140114	4B320312B-212	299	686	60	88	164	4.7	48	124	32	8	908	1620	2.8		
7427-4086	120A160"X 96"	1	1,445	3,186	YU140116	4B320312D-11	299	686	60	88	164	4.7	48	124	32	8	908	1620	2.8		
7427-4127	120A160"X 120"	1	1,141	2,515	YU140118	4B320313C-12	299	686	60	88	164	4.7	48	124	32	8	908	1620	2.8		
7427-4127	120A160"X 120"	1	1,141	2,515	YU140118	4B320313C-13	299	686	60	88	164	4.7	48	124	32	8	908	1620	2.8		
7427-4127	120A160"X 120"	1	1,141	2,515	YU140118	4B320313C-14	299	686	60	88	164	4.7	48	124	32	8	908	1620	2.8		
7427-4127	120A160"X 120"	1	1,141	2,515	YU140118	4B320313C-15	299	686	60	88	164	4.7	48	124	32	8	908	1620	2.8		
7427-4408	110A148"X 56"	1	1,073	2,367	YU140209	4B320307B-14	299	686	60	88	164	4.7	48	124	32	8	908	1620	2.8		

NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE ABOVE DESCRIBED METALS
WAS MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE

- PRIME MATERIAL, NO DIRT, NO DENTS, NO SCRATCHES
- P.O. NO. 804484 (VANCOUVER)
- SALES CONTRACT NUMBER: F06MC11
- DOCUMENTARY CREDIT NUMBER: ILCHS060294

YIEH MAU CORP.
Lin Kuen Hsing
Manager of Quality Assurance Section

